ECP4400R

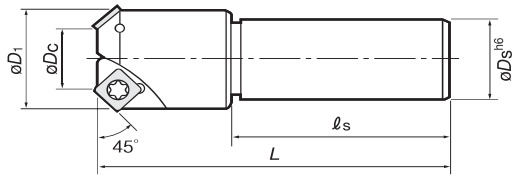
45°

P Steel K Cast Iron

Chamfering Chamfering

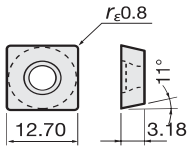
For chamfering of steels and cast irons

Rake angle: A.R. +3°(−8°) R.R.0°



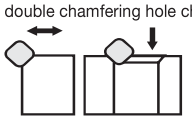
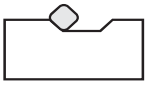
Cat. No.	Stock	No. of inserts	Dimensions (in)					Clamping screw	Wrench
			øDc	øD1	øDs	ℓs	L		
ECP440AR-U	○	1	.394	1.083	1.250	2.48	4.50	CSTA-4	T-15D
ECP4423R-U	○	2	.906	1.587					
ECP4436R-U	○	3	1.417	2.098					

Inserts



Cat. No. (Inch system)	Accuracy	Honing	Cermet		Uncoated		Application
			NS740	N308	TH10	UX30	
SPMA422TN	M	With	●	●		●	Steels
SPMA422FN		Without			●		Cast irons and light alloys

Standard cutting conditions

Operations	Work materials	Grades	Cutting speed v_c (m/min)	Maximum depth of cut a_p (mm)	Feed per tooth f_z (mm/t)
Single or double chamfering hole chamfering 	Carbon steels, Alloy steels (< 300HB)	**NS740•N308•UX30**	100 ~ 150	–	0.2 ~ 0.5
	Die steels (< 30HRC)	**NS740•N308•UX30**	50 ~ 70		0.15 ~ 0.4
	Cast irons	**TH10**	90 ~ 110	–	0.2 ~ 0.6
Facing Grooving 	Carbon steels, Alloy steels (< 300HB)	**NS740•N308•UX30**	100 ~ 150	3	0.1 ~ 0.15
	Die steels (< 30HRC)	**UX30**	50 ~ 70	2	
	Cast irons	**TH10**	90 ~ 110	3	0.1 ~ 0.15

Notes: • When chamfering stainless steel, down-milling is recommended. Conventional milling may cause edge chipping.
• When chamfering above C3.0, the feed per tooth should be set up using the lower side of the value shown in the above table.

● : Stocked items
○ : Stocked in Japan

Most unmarked items are available on a RFQ basis, contact your sales rep for more information.

Relating pages Technical Reference (14–1)